

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008719**Date Inspected:** 31-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

BAY #11

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of the U-rib to U-rib splice weld ,No. DP-3010-001-013. The welder is identified as #059416. ZPMC QC is identified as Mr.Chen Shigang .The welding variables recorded by QC appear to comply with WPS- B – T-2233-B-U2-F.

Flux Core Arc Welding (FCAW) in the 2G position of the U-rib to Deck Plate Tack weld ,No. DP-3019-001-001~010. The tack welder is identified as #059446. ZPMC QC is identified as Mr.Chen Shigang . The welding variables recorded by QC appear to comply with WPS- B – T-2342-U5b(U-rib).

Flux Core Arc Welding (FCAW) in the 3G position of the U-rib to stiffener, weld No. DP-3068-001-019/020. The welder is identified as #059443. ZPMC QC is identified as Mr.Chen Shigang .The welding variables recorded by QC appear to comply with WPS- B – T-2233-Tc-U4b-F.

Ultrasonic Testing(Phased Array)

WELDING INSPECTION REPORT

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The QA Inspector performed Phased Array Ultrasonic Testing (PAUT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which were previously tested by Caltrans QA personnel. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification numbers are

DP-482-001(11BE)

DP-131-001(11BW)

DP-483-001(11CE)

DP-481-001(11AE)

DP-267-001(10CW)

DP-106-001(11DW)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
